

Date: Thursday, 5/10/2007 2:25:38 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	RING
Job Number	32280	Part Number	D2655
Estimate Number	10608	Drawing Number	D2655 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	5/10/2007	Type	PURCHASED PARTS
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	5/30/2007
Previous Run	31489	Qty:	20
Written By	Um: Each		
Checked & Approved By	Signature: 05.10		
Comment	Est. D 00:06:22 Removed P/O for powder coat EC Est Rev:E Now on Waterjet 06-10-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M1018B400X250	Inventory
		Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s) 1018 ASTM A36 .250" thk bar x 4.0" Batch: M10237 <i>ml 07 05 15</i> (20)
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2655 Dwg Rev: B <i>ml 07 05 15</i> (20) Prog Rev: B
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 07 05 15</i> (20)
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>Co 07.06.082 X20</i> (20)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble - .030 Radius 2-Deburr any rough edges after tumbling <i>SAJ 07/06/22 20</i> (20) counted

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:25:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 32280

Part Number: D2655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

En 07/06/07

20

7.0 POWDER COATING

POWDER COATING



20X

M104144

Comment: POWDER COATING

2 Powder Coat per QSI 005 4.3.5*2*
white.

m.d

07/06/30

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2 07/07/07 20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

2 07/07/07 20

10.0 QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

07/07/07 20

Job Completion



U 07/07/07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32280
Description: Ring	Part Number:	D2655
Inspection Dwg: D2655	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

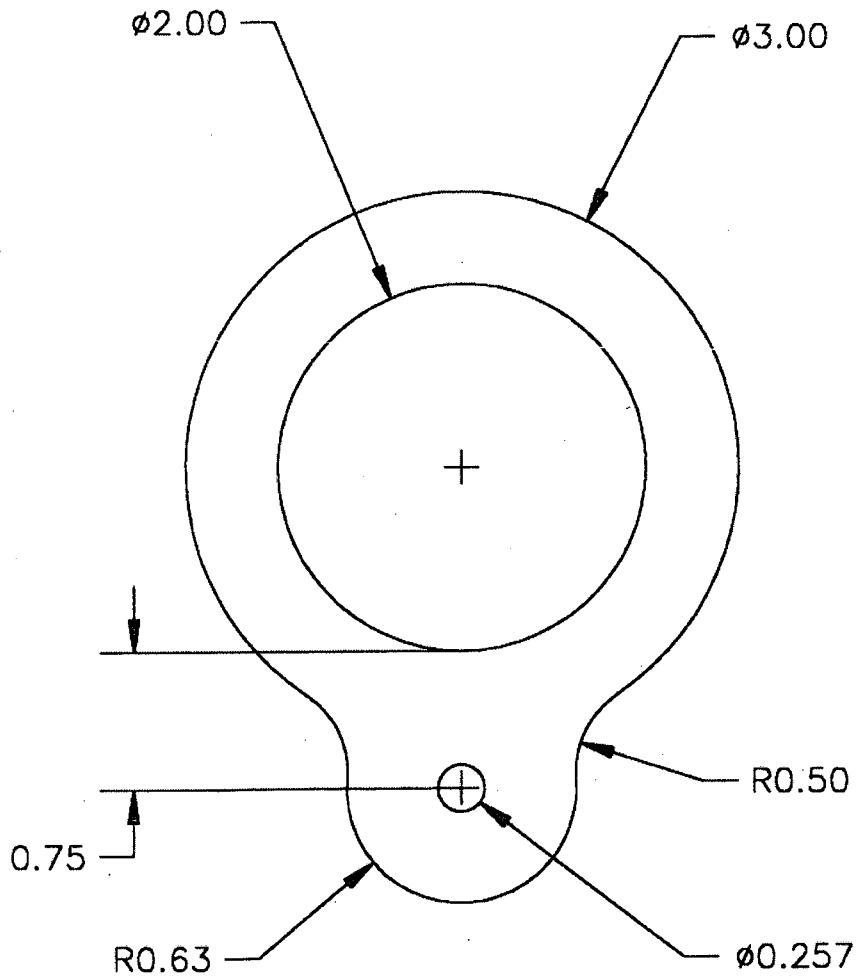
Measured by:	<u>M. Mjt</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	07/05/15	Date:	07/06/2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	SMJ



DESIGN <i>0101</i>	DRAWN BY <i>0101</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>SJ</i>	APPROVED <i>SJ</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED
47/07/97 DS



NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK

FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE
WORK ORDER
NO 32280